

Gear Hob Ø60 L60mm

A12-030

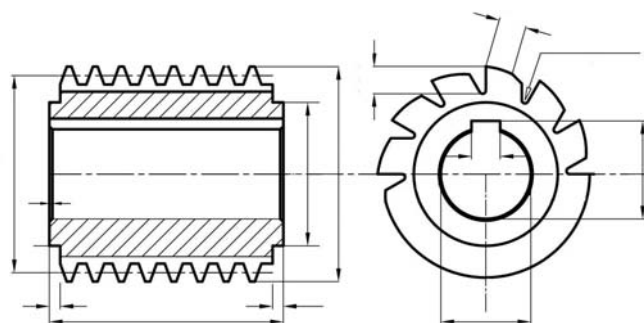
The preturned gear hob is usually profiled with a conventional wheel, which is formdressed on the integrated CNC dressing unit. With the highly dynamic linear axis of the machine, the profile execution is done at high frequency. The cycle time includes a dressing starting from a cylindrical wheel. In case the wheel is already formed the cycle time reduces drastically.



1. Cycletime for Production

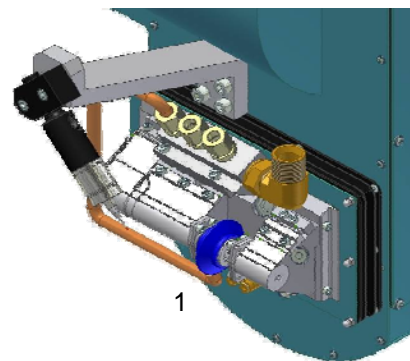
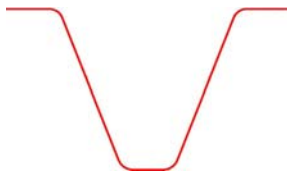
Tool specifications			
Diameter 60 mm, Length 60mm, module 2 Material HSS, 12 Gashes, 100 Teeth			
Operations	Probe	Dress	Grind
Feed [mm/Min]	2000	150	3500
Power [kW]		1	1
Cutting feed [m/s]		32	24
Used wheels		full	1
Grinding time [s]	20	1500	2280
Total cycle time	63 Min 20		

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.



2. Used Grinding Wheels

1 Ø30 DXF Conventional



3. Machine and Software Requirements



Machines: 5 axes CNC grinders : **GEMINI**ghp
 Control: Fanuc 310iA5
 Coolant: Synthetic Oil, pressure 6 - 7 bar
 Software: Quinto5, GearHobs
 Engineer: DI, 04.05.2009

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